

WHAT IS CLAIMED IS:

1. A housing used for an electronic apparatus, comprising:

an outer wall formed by injecting a metal material  
5 from a plurality of gates into a molding space in  
a metal die, wherein said outer wall includes a first  
end portion situated on an upstream end along a flowing  
direction of the metal material, a second end portion  
situated on a downstream end of the flowing direction  
10 of the metal material, and an injection portion formed  
on the first end portion where said plurality of gates  
of the metal die are situated, forming a space between  
the first end portion and the injection portion.

2. A housing according to claim 1, wherein the  
15 injection portion includes first and second edge  
portions that extend from the first end portion towards  
the second end portion and facing each other, and  
a third edge portion bridged between a distal end of  
the first edge portion and a distal end of the second  
20 edge portion.

3. A housing according to claim 1, wherein the  
metal material is a magnesium alloy and is injected in  
a half-molten state into the molding space of the metal  
die.

25 4. A housing according to claim 2, wherein said  
plurality of gates of the metal die are arranged at  
intervals along the first edge portion to the third

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edge portion.

5. A housing configured to house a functional part, comprising:

a support wall configured to support the functional part, and formed by injecting a metal material from a plurality of gates into a molding space in a metal die, wherein said support wall includes a first end portion situated on an upstream end along a flowing direction of the metal material, a second end portion situated on a downstream end of the flowing direction of the metal material, and an injection portion formed on the first end portion where said plurality of gates of the metal die are situated, forming a space between the first end portion and the injection portion.

6. A housing according to claim 5, wherein the functional part is situated between the first end portion and the second end portion of the support wall.

7. A housing according to claim 5, wherein the injection portion includes first and second edge portions that extend from the first end portion towards the second end portion and facing each other, and a third edge portion bridged between a distal end of the first edge portion and a distal end of the second edge portion.

8. A housing according to claim 5, wherein the metal material is a magnesium alloy and is injected in

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a half-molten state into the molding space of the metal die.

9. A housing according to claim 7, wherein the injection portion of the support wall is covered by  
5 a synthetic-resin made cover, and the cover is fixed to the support wall by a plurality of locations along the first edge portion to the third edge portion of the injection portion.

10. A housing, comprising:  
10 a support wall configured to support a functional part; and

15 a pair of projecting portions projecting from the support wall at intervals, wherein, said support wall is formed by injecting a metal material from a plurality of gates into a molding space in a metal die, and said support wall includes a first end portion on which the projecting portions are situated, a second end portion situated on an opposite side to the first end portion, and an injection portion formed on the  
20 first end portion where said plurality of gates of the metal die are situated, forming a space between the first end portion and the injection portion.

25 11. A housing according to claim 10, wherein the first end portion of the support wall is situated on an upstream end along a flowing direction of the metal material, and the second end portion of the support wall is situated on a downstream end of the flowing

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direction of the metal material.

12. A housing according to claim 11, wherein the functional part is situated between the first end portion and the second end portion of the support wall.

5 13. A housing according to claim 10, further including: a synthetic-resin-made cover configured to cover the injection portion of the support wall, the cover being fixed to the support wall and situated between the projecting portions.

10 14. An electronic apparatus, comprising:  
a housing configured to house a functional part, and formed by injecting a metal material from a plurality of gates into a molding space in a metal die, wherein said housing includes a first end portion  
15 situated on an upstream end along a flowing direction of the metal material, a second end portion situated on a downstream end of the flowing direction of the metal material, and an injection portion formed on the first end portion where said plurality of gates of the metal die are situated, forming a space between the first end portion and the injection portion.

20 15. A housing according to claim 14, further including: a synthetic-resin-made cover configured to cover the injection portion of the housing, the cover  
25 being fixed to the housing.

16. A display unit, comprising:  
a support wall formed by injecting a metal

material from a plurality of gates into a molding space in a metal die, wherein said support wall includes a first end portion situated on an upstream end along a flowing direction of the metal material, a second end portion situated on a downstream end of the flowing direction of the metal material, and an injection portion formed on the first end portion where said plurality of gates of the metal die are situated, forming a space between the first end portion and the injection portion; and

10 a display panel situated between the first end portion and the second end portion of the support wall.

15 17. A display unit according to claim 16, wherein the injection portion includes first and second edge portions that extend from the first end portion towards the second end portion and facing each other, and a third edge portion bridged between a distal end of the first edge portion and a distal end of the second edge portion.

20 18. A display unit according to claim 16, wherein the metal material is a magnesium alloy and is injected in a half-molten state into the molding space of the metal die.

25 19. A display unit according to claim 16, wherein the display panel is a liquid crystal display panel.

20. A display unit according to claim 17, wherein the injection portion of the support wall is covered by

a synthetic-resin made cover, and the cover is fixed to the support wall by a plurality of locations along the first edge portion to the third edge portion of the injection portion.

5 21. A portable computer system, comprising:

a support wall formed by injecting a metal material from a plurality of gates into a molding space in a metal die, wherein said support wall includes a first end portion situated on an upstream end along 10 a flowing direction of the metal material, a second end portion situated on a downstream end of the flowing direction of the metal material, and an injection portion formed on the first end portion where said plurality of gates of the metal die are situated, 15 forming a space between the first end portion and the injection portion;

a display panel situated between the first end portion and the second end portion of the support wall; and

20 a computer main body having a keyboard, the computer main body being in electric communication with the display panel.

22. A portable computer system according to claim 21, wherein the injection portion includes 25 first and second edge portions that extend from the first end portion towards the second end portion and facing each other, and a third edge portion bridged

between a distal end of the first edge portion and a distal end of the second edge portion.

23. A portable computer system according to claim 21, wherein the metal material is a magnesium alloy and is injected in a half-molten state into 5 the molding space of the metal die.

24. A portable computer system according to claim 21, wherein the display panel is a liquid crystal display panel.

10 25. A portable computer system according to claim 22, wherein the injection portion of the support wall is covered by a synthetic-resin made cover, and the cover is fixed to the support wall by a plurality of locations along the first edge portion to the third edge portion of the injection portion.

15 26. A method of forming a housing for an electronic apparatus, comprising:

providing a metal material to form a support wall of the housing;

20 heating the metal material into a half-molten state;

injecting the metal material from a plurality of gates into a molding space in a metal die; and

25 forming said support wall having a first end portion situated on an upstream end along a flowing direction of the metal material, a second end portion situated on a downstream end of the flowing direction

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of the metal material, and an injection portion formed on the first end portion where said plurality of gates of the metal die are situated, forming a space between the first end portion and the injection portion.

5        27. The method according to claim 26, further including:

covering the injection portion of the support wall by a synthetic-resin made cover; and  
fixing the cover to the support wall by  
10      a plurality of locations along the first edge portion to the third edge portion of the injection portion.

28. The method according to claim 26, wherein the metal material is a magnesium alloy.